

# Work Order ID 84772

**\*84772\***

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Wednesday, May 23, 2012 8:23:46 AM

Item ID: D3917-3      Accept      **\*N900040100\***      Setup Start **\*NS1\***  
 Revision ID:      Stop **\*NS2\***  
 Item Name: Washer  
 Start Date: 5/23/2012      Start Qty: 1.00      **\*1\***      Cust Item ID:  
 Required Date: 5/23/2012      Req'd Qty: 1.00      **\*1\***      Customer:  
 Reference:

Approvals:      Process Plan: ME      Date: 12-05-23      Tooling:      Date:      Run Start **\*NR1\***  
 QC:      Date:      SPC (Y/N):      Date:      Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3917	A

100	0.00	<u>12-5-23</u>	/
<b>*100*</b>	0.00		

Hardinge

Hardinge CNC Lathe Small

Memo

TURN AS PER FOLIO FA876 & DWG  
 FOLIO REV: \_\_\_\_\_  
 DWG REV: \_\_\_\_\_

DEBURR

*Manual*

110	0.00	<u>12-5-23</u>	/
<b>*110*</b>	0.00		

QC

Quality Control

Memo

QC2- Inspect parts off machine FAI/FAIB

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**\*84772\***

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**Accept**

**\*N900040100\***

Setup Start \*NS1\*

Stop \*NS2\*

**Start Date:** 5/23/2012      **Start Qty:** 1.00

**\* 1 \***

**Cust Item ID:**

**Required Date: 5/23/2012      Req'd Qty: 1.00**

**\* 1 \***

**Customer:**

**Reference:**

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run	Start	*NR1*
	Stop	*NR2*

## Operation Description

### Set Up/ Run Hours

## Tool ID

Tool #

## Plan Code

**Accept Qty**

Reject  
QtyReject  
Number

**Insp.  
Stamp**

120

QC8- Inspect parts - second check

0.00

**\*120\***

QC

## Memo

0.00

## Quality Control

130

Identify as per dwg & Stock Location: *SH 495*

0.00

**\*130\***

### Packaging

## Memo

0.00

## Packaging

140

QC21- Final Inspection - Work Order Release

0.00

**\*140\***

QC

## Memo

0.00

## Quality Control

12/5/23 DJ  
MF 12-05-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Picklist Print

Wednesday, May 23, 2012 8:23:46 AM

Page 1

Work Order ID: 84772

Parent Item: D3917-3

Parent Item Name: Washer

Start Date: 5/23/2012

Required Date: 5/23/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: Ipp Rev:A New Issue 09-12-02 JLM Verified by:DD IPP Rev:B as per dwg REV.A DD  
10.02.22 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MDELNR0.750 Delrin Round Bar 0.75"		Purchased	No			100	f	210.1750	0.02	0.0210526			

Location

Loc Qty

Loc Code

MAT055

210.175

116183

2.4

117273

1.555

117322

0.94

120722

5.28

121783

200

.1

9/12-5-23

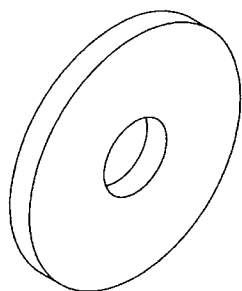
W/O:		WORK ORDER CHANGES					
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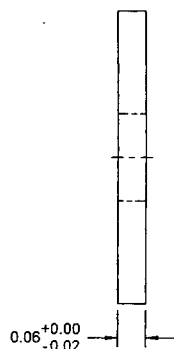
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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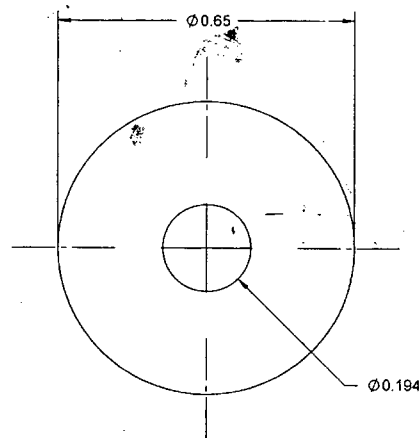
**NOTE:** Date & initial all entries



ISO VIEW

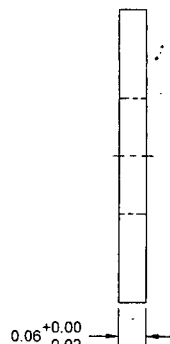


0.06<sup>+0.00</sup>  
-0.02

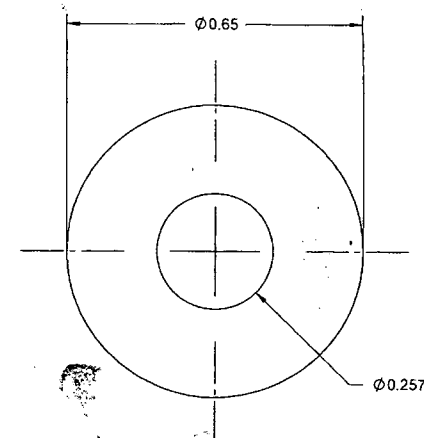


D3917-1 WASHER

#84772



0.06<sup>+0.00</sup>  
-0.02



D3917-3 WASHER

RELEASED  
2010-02-16

NOTES:

- 1) MATERIAL: DELRIN II 150E OR ACETRON GP ACETAL, COLOR BLACK  
REF DART SPEC M-DELRIN-R
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: < 0.01 lbs

A		NEW ISSUE		JPH	10.01.29
REV.		DESCRIPTION		BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		REV. A	
DRAWN	AJS			SHEET 1 OF 1	
CHECKED	[Signature]	DRAWING NO. D3917		SCALE	
MFG. APPR.	[Signature]	TITLE		NTS	
APPROVED	[Signature]	WASHER (350 BASKET)			
DE APPR.	[Signature]	DATE 10.01.29		COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED IN THE EXEMPT CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

**Dart Aerospace Ltd**

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